Page 1

January 27, 2010 11:26:06 AM

Item ID:

D3573-3

Accept

Setup Start

Stop



Revision ID:

Item Name: Start Date:

Required Date: 2/05/10

Adapter

1/27/10

QC:

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Process Plan:

Date: 10-1-27 Tooling:

Run

Start

Approvals:

Date:

SPC (Y/N):

Date:

Date:

Rev.

Stop

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours**

Draw Number

Plan Draw Code

Accept Qty

Reject Qty

Reject Number

Stamp

Draw Nbr

Revision Nbr

D3573

Rev A

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 3.500" long

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

0.00

Machine as per Folio FA673 and Dwg D3573

10.10-29

QC2- Inspect parts off machine FAI/FAIB

HAAS CNC VERTICAL MACHINING #1

16 10.10.29



120

QC

Memo

0.00

Quality Control

Dart Ae	rospace Ltd								•
W/O:			W	ORK ORDER CH	ANGES				`
DATE	STEP	PRO	DCEDURE CH	IANGE	B	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		The second section is	Martin (1997) - 1 of American						·
Part No	:	PAR #:	Fault Ca	tegory:	NCR: \	es No DC	A:	Date:	
	Resolut	tion:	Disposit	ion:	QA: N/	C Closed:		Date:	_
NCR:		1	WORK OR	DER NON-CONFO	RMANCE (N	ICR)			

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B	Verification	Approval	Ammusical	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Ord January 27, 20											Pag
Item ID: Revision ID: Item Name:	D3573-3 Adapter			Accept				IIII s	Setup Sta		
Start Date: Required Date Reference:	1/27/10	Start Qty: 10.00 Req'd Qty: 10.00			Cust Item II Customer:	D:	•	ì	<i>)</i> {	(
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ite:		ŀ	Run Sta Sto		
Sequence ID/ Work Center 130 QC Quality Control		Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		Chemical Conversion Co	at per QSI005 4.1	0.00 BL	10-02-01				Ø.	,	

150

Powdercoat

HandFinish

Hand Finishing

Powder Coating

Memo

Memo

0.00

START TIME: 6'-4.

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Categ	Jory:	NCR: Yes	No DQ	A:	Date: _	
	Resolution:		Disposition	1:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	3)			
DATE	STEP	Description of NC	Corrective Action Sec			Verific	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Secti		Chief Eng	QC Inspector
			:						
					l	1			1

Work Order ID 55681

Page 3

January 27, 2010 11:26:06 AM

Item ID:

D3573-3

Accept

Setup Start

Stop



Revision ID:

Start Date:

Adapter **Item Name:**

Required Date: 2/05/10

1/27/10

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Date:

SPC (Y/N):

Date:

Draw

Plan

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ **Work Center ID**

160

Quality Control

Operation **Description**

QC:

QC3- Inspect Part Finish

Memo

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Number Code Rev. BK 10-02-3

Accept

Qty

170

Packaging Packaging

Identify as per dwg & Stock Location: 24

0.00

0.00

180

QC

Quality Control

OC21- Final Inspection - Work Order Release

0.00

0.00

Dant Ae	ospace	ELIG								7	
W/O:			WC	RK ORDER CH	ANGES						
DATE	STEP	PROC	CEDURE CHAI	NGE	212-200	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	_ Fault Cate	gory:	NCI	R: Yes	No DQ	A :	Date:		
	R	esolution:	_ Disposition	n:	QA	N/C Cld	osed:		Date: _		
NCR:		W	ORK ORDI	ORK ORDER NON-CONFORMAN			MANCE (NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descrip	Section B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector	
		OCCIONA	Chief Eng	Chief Eng		Date	Seci		Offier Eng	QC inspector	

Picklist Print

January 27, 2010 11:26:10 AM

Work Order ID: 55681

D3573-3 Parent Item:

Parent Item Name: Adapter

Comments:

IPP Rev:A New Issue 07-01-29 JLM

A 10 10 29

Start Date: 1/27/10

Required Date: 2/05/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6B0.500X02.50		Purchased	No			100	f	31.0923	3.0737			

6061-T6 Bar .500 x 2.50

Loc Qty Warehouse

Loc Code

Location

Main Warehouse

31.09231579

42(3.5') 1.06

MAT

30.0323158

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W/O: DATE STEP			WO	RK ORDER CHANG	ES			· · · · · · · · · · · · · · · · · · ·		1
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
Res		solution:	Disposition	l:	_ QA:	N/C CI	osed:	*****	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCF	?)			
DATE	OTED	Description of NC		ion B		Verific	ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Section		Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	55681
Description: Adapter	Part Number:	D3573-3
Inspection Dwg: D3573 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
3.31	+/-0.030	3.31				
2.69	+/-0.030	2.69				
2.31	+/-0.030	2.31				
1.600	+/-0.005	1.600				
0.36	+/-0.030	.76				
1.19	+/-0.030	1.19				
2.38	+/-0.030	2.38				
1.420	+/-0.010	1.420				
0.48	+/-0.030	. 480				
R0.63	+/-0.030	1.63				
R0.13	+/-0.030	R.13				
R0.02	+/-0.030	1.005				
Ø0.209	+0.005/-0.001	.210				
Ø0.266	+0.006/-0.001	, 269				
0.390	+0.010/-0.000	,393				
Ø0.675 x 0.190	+/-0.010	.680 x. 190				
Ø0.500 x 0.310	+/-0.010	,5 x.31				
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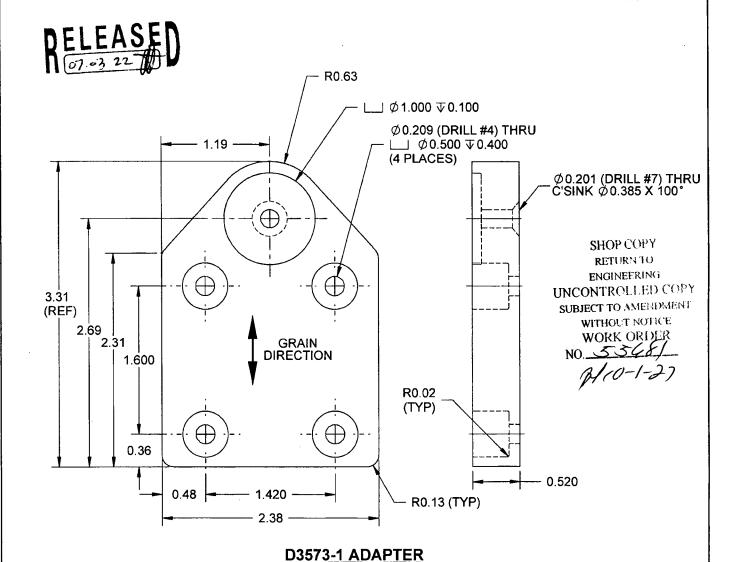
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10.10.29	Date: 10/01/29	Date:	N/A

Rev	Date	Change	Revised by A	Approyed
Α	07.04.04	New Issue	KJ/JLM KJ/	
				

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W/O:			W	ORK ORDER CHANG	ES				• •
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
			W.						
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	Date: _	
	Re	esolution:	Dispositio	_ QA: N/C C	losed:	Date: _			
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NCI	₹)	,		
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval
	J.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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07.02.19			ADAPTER		SCALE 1:1					
REV		DATE		DESCRIPTION						
Α		07.02.19	NEW ISSUE							



NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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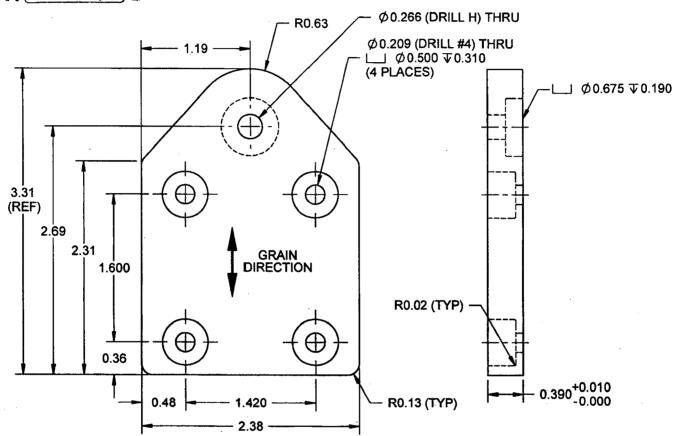
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W/O:			W	ORK ORDER CHANGE	ES	******			
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section		Veri	fication	Approval Chief Eng	Approval
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- WO 55481

RELEASED



D3573-3 ADAPTER

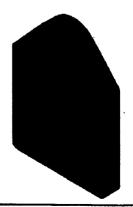
1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



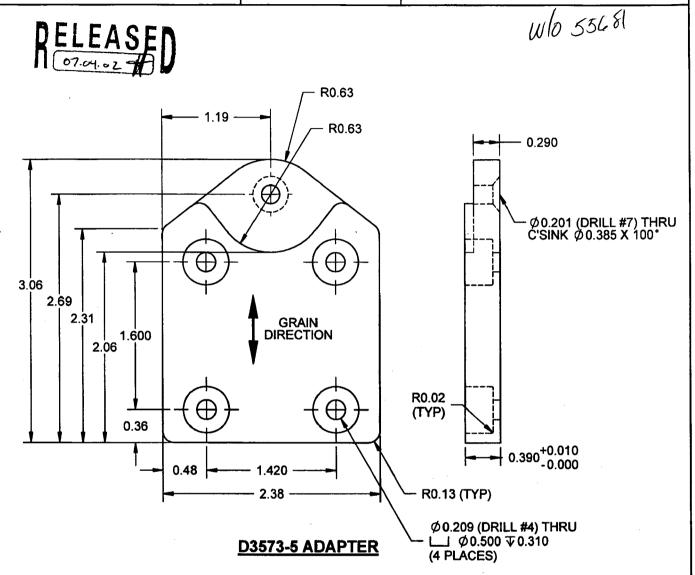
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W/O:			WO	RK ORDER CHANG	SES						
DATE STEP		PRO	PROCEDURE CHANGE			у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No: PAR #:		PAR #:	Fault Category: NO			NCR: Yes No DQA: D					
Resolution:			Disposition: Q			QA: N/C Closed: Date					
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DATE 07.0	02.19	TITLE ADAPTER	SCALE 1:1			



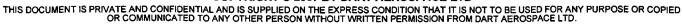
1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

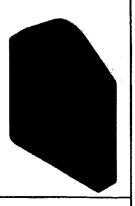
(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX







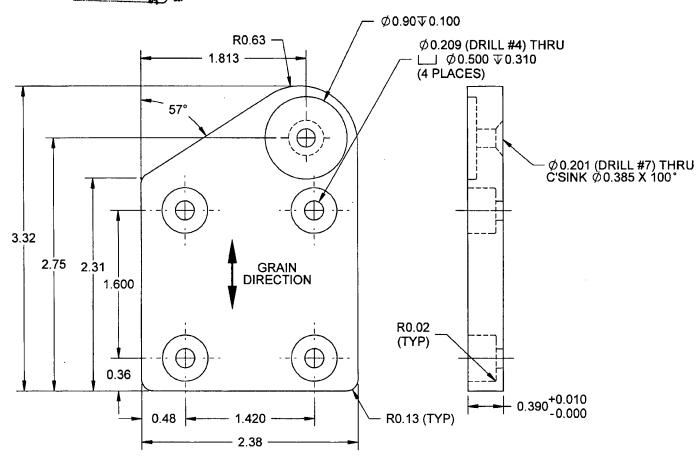
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Resolution:			Disposition: Q			N/C CI	sed:	Date:				
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PH		D3573	SHEET 4 OF 4				
DATE		TITLE	SCALE				
07.	02.19	ADAPTER	1:1				

RELEASED 67.04.02

W/0 35681



D3573-7 ADAPTER (SHOWN) **D3573-8 ADAPTER (OPPOSITE)**

NOTES:

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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W/O:			WC	RK ORDER CHANGE	ES				•
DATE STEP		PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:			Disposition: Q			closed:	Date:		
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
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